

Work Order ID 155464

Tuesday, January 17, 2017 10:31:22 AM

155464

Page 1

Item ID: D120-638-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC120 Bearpaws

Start Date: 1/17/2017 Start Qty: 1.00

~~*1*~~

Cust Item ID:

Required Date: 1/31/2017 Req'd Qty: 1.00

~~*1*~~

Customer:

Reference:

Approvals: Process Plan:

DAS
21
9-89

Date: JAN 17 2017 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

JAN 17 2017

DAS
6
9-89

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

2x

DAS
28
9-89

JAN 17 2017

JAN 17 2017

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

2

JAN 17 2017

DAS
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27
9-89

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.01

Quality Control

2x

DAS
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Work Order ID 155464

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Page 2

Item ID: D120-638-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC120 Bearpaws

Start Date: 1/17/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/31/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180	Packaging	0.00							
Packaging	Memo								
	Identify and pack for shipping as per PPPD120-638-011								
	LOCATION: FG014								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.02							
Quality Control									

2x

DAS
28
9-89

DAS
27
9-89

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JAN 17 2017

Picklist Print

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Work Order ID: 155464

155464

Parent Item: D120-638-011

D120-638-011

Parent Item Name: EC120 Bearpaws

Start Date: 1/17/2017

Required Date: 1/31/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2435

Manufactured

No

160

Each

5.0000

2

24

**

JAN 17 2017

D2435
Bearpaw

DAS
28
9-89

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST446A

5

150969

1

151962

4

D2182B050

Manufactured

No

160

Each

55.0000

4

48

**

JAN 17 2017

D2182B050
Clamp Cushion Black 5.0 " Long

DAS
28
9-89

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST639

55

151596

5

152511

50

D2274

Manufactured

No

160

Each

607.0000

8

816

**

JAN 17 2017

D2274
Radius Block

DAS
28
9-89

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

292

150353

1

151763

291

ST012a

303

152449

303

16

Picklist Print

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Page 2

Work Order ID: 155464

Parent Item: D120-638-011

Parent Item Name: EC120 Bearpaws

155464

D120-638-011

Start Date: 1/17/2017

Required Date: 1/31/2017

Start Qty: 1.00

Required Qty: 1.00

D2438

Manufactured No

160 Each

51.0000

4

48

D2438

Clamp

DAS
28
9-89

**

JAN 17 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST542

51

151376

27

152451

24

8

D2529

Manufactured No

160 Each

979.0000

8

216

D2529

Washer

DAS
28
9-89

**

JAN 17 2017

DAS
6
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DAS
27
9-89

Location

Loc Qty

Loc Code

ST008

979

153945

79

154187

100

155073

800

16

AN4-15A

Purchased No

160 Each

793.0000

8

216

AN4-15A

Bolt

DAS
28
9-89

**

JAN 17 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

10

120449

10

over003

645

m135859

645

ST343

138

m135859

138

16

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 155464

Parent Item: D120-638-011

Parent Item Name: EC120 Bearpaws

155464

D120-638-011

Start Date: 1/17/2017

Required Date: 1/31/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

160

Each

2,497.000

8

8/16

NAS1149D0463.I

Washer

**

DAS
6
9-89

JAN 17 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	80	
M134508	13	
M135056	67	
ST260a	1200	
M136192	600	
M136263	600	
ST263	1217	
M136044	217	
M136406	1000	

16

MS21042L4

Purchased

No

160

Each

1,873.000

8

8/16

MS21042I 4

Nut

**

DAS
6
9-89

JAN 17 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001	18	
m133363	18	
GA	192	
m135058	192	
OVER007	500	
m136450	500	
ST303	1163	
m136182	500	
m136295	663	

16

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Shop Packet Print

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DART



RELEASED
19.06.17 KE

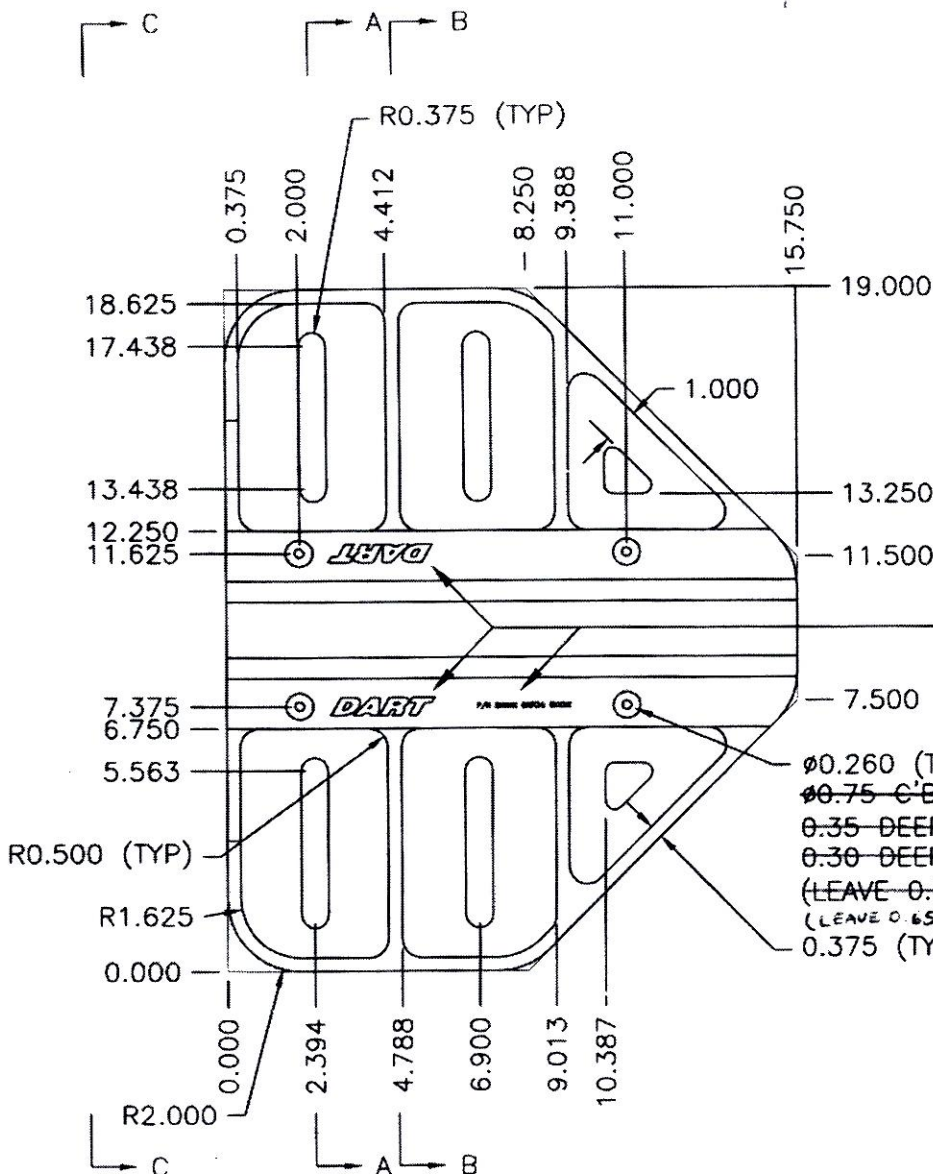
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	

A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155464 MJS
170-17

EFFECTIVE DEOS
9143

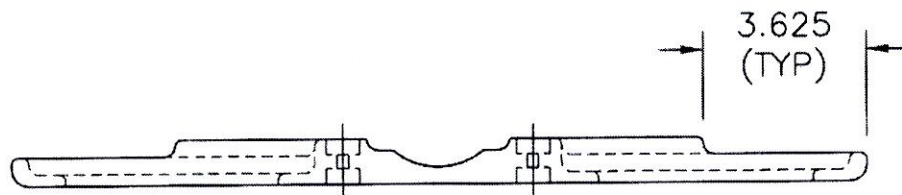
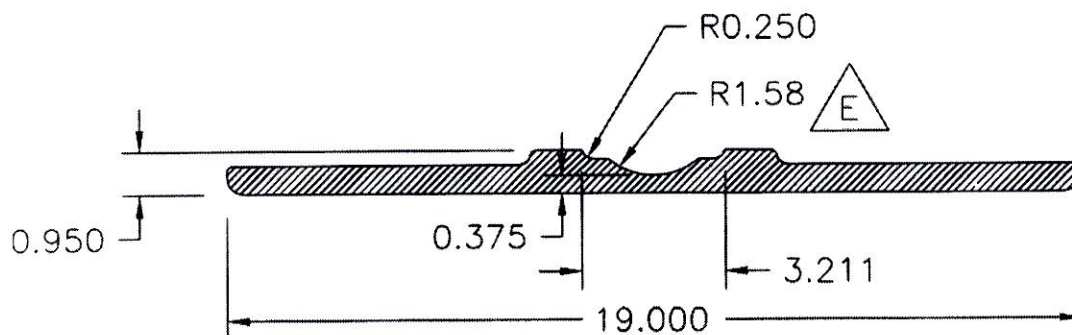
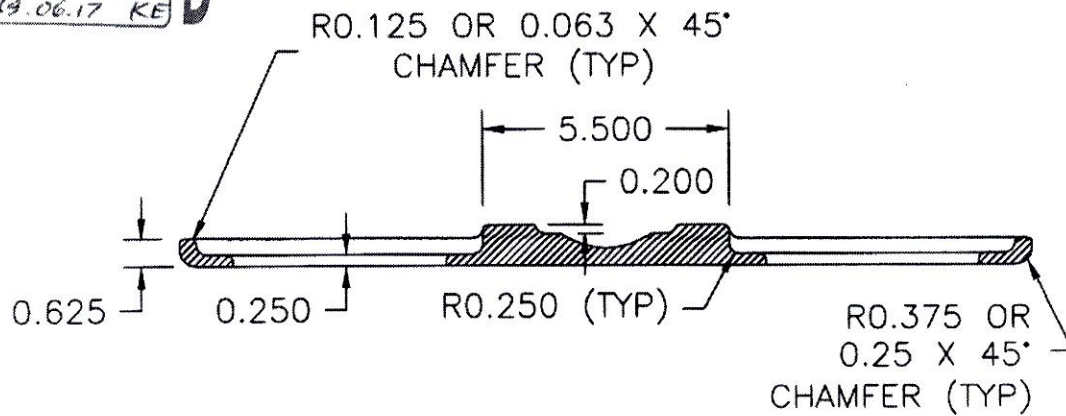


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



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Item ID: D120-638-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC120 Bearpaws

Start Date: 1/17/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/31/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2435	Rev E1
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100	Document Control	0.00							
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100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

DAS
21
9-89

JAN 17 2017



160	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

160

Packaging

Memo

0.00

Packaging

170	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

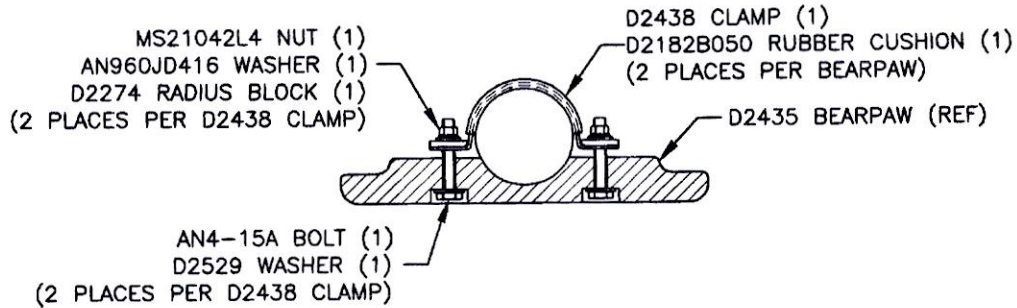
170

QC

Memo

0.01

Quality Control

*Figure 2 – Bearpaw Installation*

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D120-638-011	BEARPAW INSTALLATION
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)